

Work Order ID 83343

83343

Page 1

April-17-12 2:17:07 PM

Item ID: D3512-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Wearplate

Stop ***NS2***

Start Date: 17/04/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 01/05/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/17 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3512	Rev C								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3512 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

384.063

B12-4-21

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-4-21

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Sizku/23

4/8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

NC BRAKE

Brake NC

Memo

0.00

Brake NC

Deburr if necessary Form as per dwg D3512 using DT8179

18

0

SP
12/04/24

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

Schultz

(18) f

150

Large Fab

0.00

150

Large Fab

Memo

0.00

Large Fab

Weld hard surface using DT8874 as per Dwg D3512 & QSI 004Qty

Description BatchA/R 2059b Hardcoat Rod m 120013

(18) ME

12-05-07

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Cust Item ID:

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12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

160

QC

Memo

0.00

5/17/07

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

8/21/07

Quality Control

7/8

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

180

Powdercoat

Memo

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3200 F

320

18X

ML
12/05/08

MU7338

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

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Cust Item ID:

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

18 0 125-8.

200

Identify as per dwg & Stock Location: 501

0.00

200

Packaging

Memo

0.00

Packaging

18 125/102

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/5/10

MF
12-05-10

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Picklist Print

April-17-12 2:17:11 PM

Page 1

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83343

Parent Item: D3512-1

D3512-1

Parent Item Name: Wearplate

Start Date: 17/04/2012

Required Date: 01/05/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-06-20 JLM
IPP Rev:B Now SS as per Rev B 06-12-15 JLM
IPP Rev:C Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	231.6520	0.261	3.296842	S,		

M304S16GA

304/316 Sheet .063

**

B12-421

Location

Loc Qty

Loc Code

MAT020

231.652

120866

38.446

120877

137.326

121070

55.88

120866

(18)

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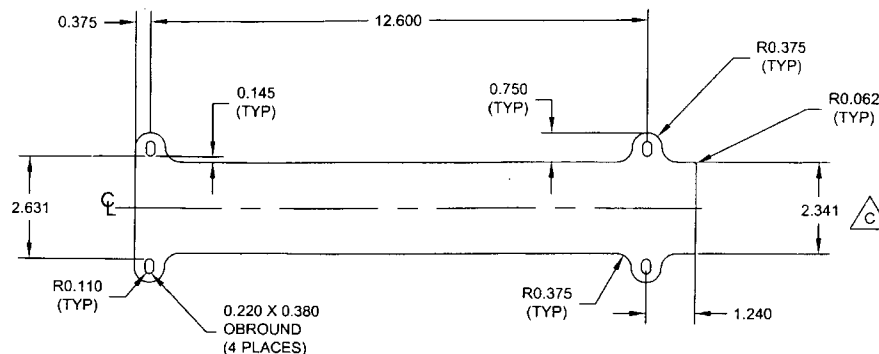
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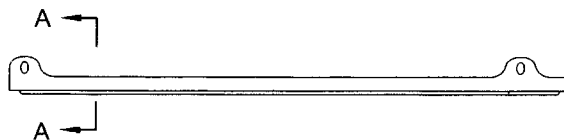
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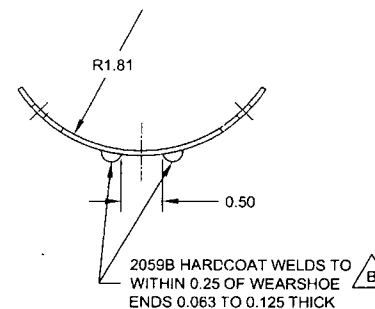
NOTE: Date & initial all entries



D3512-1F FLAT PATTERN



D3512-1 BENDING DETAIL



SECTION A-A
SCALE 2:3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83343 MLJ

12/04/17

RELEASED
67.11.14 16/1



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs

C	ENLARGE OBOUND FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.05		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3512
SHEET 1 OF 1

TITLE WEARPLATE
SCALE 1:3

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